

[illegible]

August 11, 2010 10:40:58 AM

Accept

**Setup Start**[illegible]

Stop

[illegible]

Start

[illegible][illegible]**Cust Item ID:**

Customer:

Reference:

Stop



Approvals: Process Plan: C2

Date: 10/8/11 Tooling:

Date: _____

QC: _____

Date: _____ **SPC (Y/N):** _____

Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61221

August 11, 2010 10:40:58 AM



Page 2

Item ID: D3001-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 8/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sub 68116

(44)

130



Small Fab

Small Fab

Small Fab

Memo

1-Scuff surfaces with 80grit sandpaper per QSI 006
2-Deburr.

0.00

0.00

E 50/08/17 (11x)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

810/09/17

(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61221

August 11, 2010 10:40:58 AM



Page 3

Item ID: D3001-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 8/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 08 18 (11)

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=) MU 10/08/18

X11 0

170

Identify as per dwg & Stock Location: ST 178

0.00



Packaging

Memo

0.00

Packaging

CZ 10/8/18 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61221

August 11, 2010 10:40:58 AM



Page 4

Item ID: D3001-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 8/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/19 DJ

CL101818

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 11, 2010 10:40:58 AM

Page 1

Work Order ID: 61221



Parent Item: D3001-1



Parent Item Name: Doubler

Start Date: 8/11/10

Required Date: 8/13/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 01.03.22 New Issue EC
 IPP rev.B added scuffing NCR 061 EC
 IPP Rev:C Now On Waterjet 07-12-13 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	55.0234	0.7083	7.455789	7.8		
											R 10-8-16		

5052-H32 .040 Sheet

Location	Loc Qty	Loc Code
MAT	43.6	
114488	43.6	
MAT23	11.4234	
101875	1.5	
109058	8.5234	
113123	1.4	

114488

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

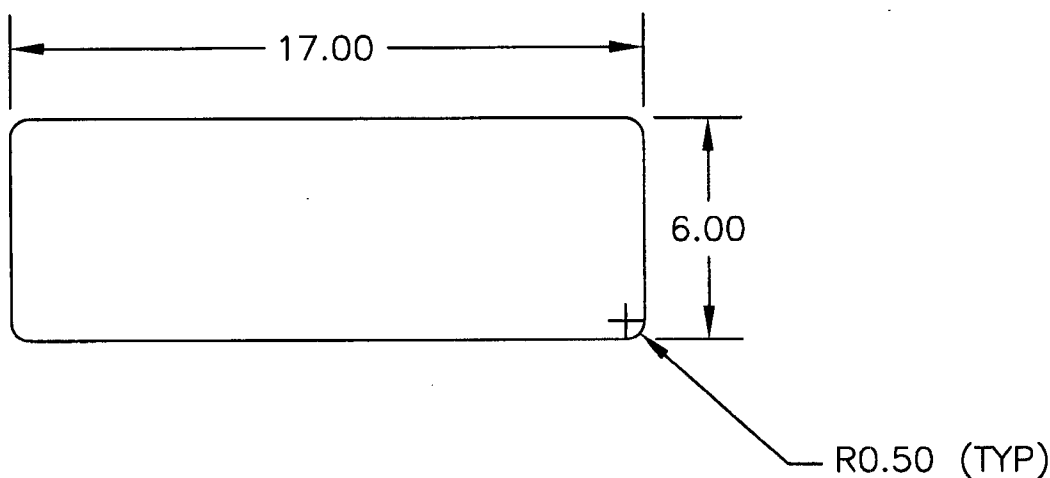
NOTE: Date & initial all entries

DART

RELEASE

06.11.03

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
90	CB	DRAWING NO.	REV. B
CHECKED XJH	APPROVED H	D3001	SHEET 1 OF 1
DATE 06.10.06		TITLE DOUBLER	SCALE 1:5
A	01.03.21	NEW ISSUE	
B	06.10.06	ADD BONDING PREP NOTE	



NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040)
OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) PREPARE FOR BONDING TO COMPOSITE STRUCTURE
PER DART QSI 006 4.10
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS TO 0.010 MAX